

580



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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D5570-1

Job Sheet 199969



Part No: D5570-1

Job Qty: 4 pcs

Part Name: Blade Plug



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 9/5/19

Job Tracking No:

Due Date: 10/11/19

Created By: Marie Lajeunesse

Type: Stock

Description: SIOP

Note: TBD DWG D5570-1 REV:A IPP REV:A NEW ISSUE 18/06/21 JFS VERIFIED BY:DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	NLX 2500SY - 1	4 pcs	10/11/19	10/11/19	1.00	2.00	NLX 2500SY - 1		
110	QC 2	4 pcs	10/11/19	10/11/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		
							QC 2 - 64		
							QC 2 - 65		



Container No: S214706



Part: D5570-1

Job No: 199969

Serial No/Batch: S214706

Revision: A

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 09/10/19

120 QC 8	4 pcs	10/11/19	0.00 0.00	QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
				QC 8 - 12	
				QC 8 - 14	9/19/09/20
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
				QC 8 - 57	
130 Packaging 3-1 - Stock - B4B	4 pcs	10/11/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	

DAF
28
9-89

9/5/2019

[Dart Hawkesbury] Job Sheet - Lajeunesse, Marie

				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
140 QC 21 - SA	4 pcs	10/11/19	0.00 0.00	QC 21 - SA - 21	DAS
				QC 21 - SA - 70	SEP 24 2019 70
				QC 21 - SA - 53	9-89
Part Op 100 - NLX (MORI NLX 2500SY LATHE) ***Note***6,000" makes _____ pieces, 1-Machine as per DWG. & Folio FC158 Descriptions: FOLIO REV: <u>AA</u> DWG REV: <u>A</u> 2-Debur 110 - (QC2- Inspect parts off machine FAI/FAIB) 120 - (QC8- Inspect parts - second check) 130 - (Identify as per dwg & Stock Location: _____) 140 - (QC21- Final Inspection - Work Order Release)					
Job BOM					
Part / Item	Component Name	Quantity	Operation	Container	
MUHMWR3.000-B	UHMW Rod (Round Bar), Black	.6680 ft (.167 ea)	100-NLX 2500SY - 1	S 199 589	
Job Allocations					
Operation	Component Part	Required	Inventory	Allocated	
100-NLX 2500SY - 1	MUHMWR3.000-B	1	6	0	
Part Specifications					
Specifications could not be found.					

Plex 9/5/19 10:39 AM Dart.lajeunesse.marie



Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

Route update only ☐

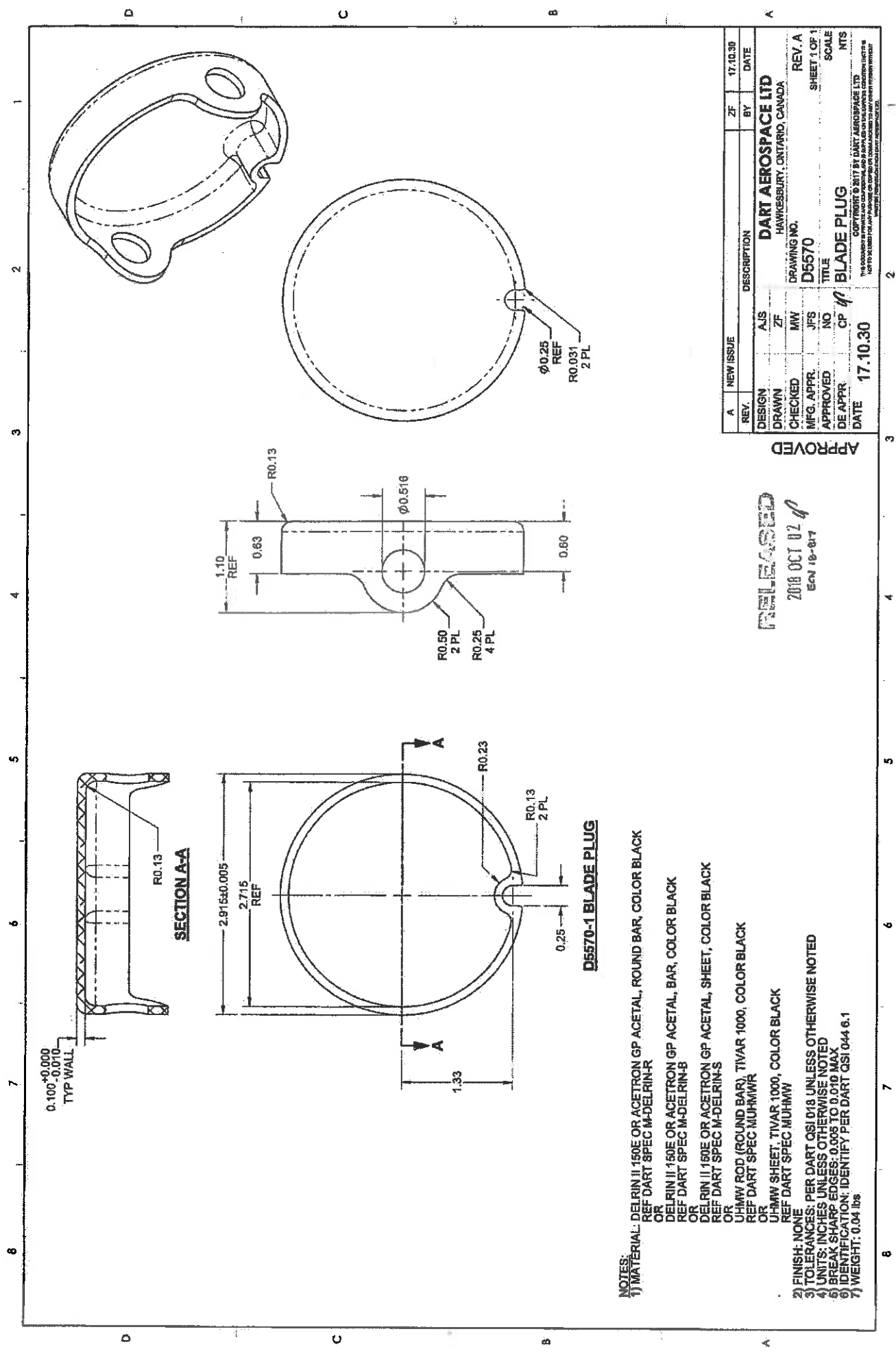
NCR No. _____

Job: _____ Part No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐		DEPARTMENT/PROCESS Cross tube ☐ Eng. (Non-AW) ☐ Small Fab ☐ Prod. Eng. Coord. ☐ Finishing ☐ Rec/Store/Packaging ☐ Skid-tube ☐ Machining ☐ Large Fab ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date: _____	Sequence #: _____	QTY Affected: _____		MRB (QS1042)			
Description Work Order Deviation				Disposition			
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY					
		Pressure/Forced Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Other/Details: _____		Contamination Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐		Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐	

Completed By

Lead hand / Supervisor

QC / QA Coordinator



D5570-1 BLADE PLUG

- NOTES:
- 1) MATERIAL: DELRIN II 150E OR ACETRON GP ACETAL, ROUND BAR, COLOR BLACK
REF DART SPEC M-DELIRIN-R
OR
DELIRIN II 150E OR ACETRON GP ACETAL, BAR, COLOR BLACK
REF DART SPEC M-DELIRIN-B
OR
DELIRIN II 150E OR ACETRON GP ACETAL, SHEET, COLOR BLACK
REF DART SPEC M-DELIRIN-S
OR
UHMW ROD (ROUND BAR), TIVAR 1000, COLOR BLACK
REF DART SPEC MUH-MWR
OR
UHMW SHEET, TIVAR 1000, COLOR BLACK
REF DART SPEC MUH-MW
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 0418 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY PER DART QSI 044 6.1
 - 7) WEIGHT: 0.04 lbs

RELEASED
2018 OCT 02
ECN 18-017

APPROVED

REV.	NEW ISSUE	DESCRIPTION	ZF	BY	DATE
A					17.10.30
DESIGN	AJS				
DRAWN	ZF				
CHECKED	MW				
ING. APPR.	JPS				
APPROVED	NO				
DE APPR	CP				
DATE	17.10.30				
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA					
DRAWING NO. D5570					
REV. A					
SHEET 1 OF 1					
SCALE					
NTS					
BLADE PLUG					
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